

Work Order ID 84802

84802

Page 1

May-23-12 11:31:30 AM

Item ID: D2435 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw, 206
 Start Date: 23/05/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/06/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/23 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1					(10)		36	

120 0.00

120

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

12-6-2

130 0.00

130

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
 3-Deburr

12-06-30 (10) 12-6-2

140 0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

12-06-30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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150 QC8- Inspect parts - second check 0.00

150

QC

Memo

0.00

Quality Control

151 Identify as per dwg & Stock Location: *Ship* 0.00

151

Packaging

Memo

0.00

Packaging

190 QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

10 *12/06/30* *10* *0*
10x *Sp*
12-7-3
12/2/3
MF
12-07-03

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Picklist Print

May-23-12 11:31:34 AM

Page 1

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Parent Item: D2435

D2435

Parent Item Name: Bearpaw, 206

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

53.2100

3.2

32

36,

MUHMWB10

**

1362-6-2

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

30.1

120972

3

121346

27.1

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

121851

10

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DART AEROSPACE LTD		Work Order:	89802
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010					
B	5.500	+/-0.030	5.502	✓			
C	0.200	+/-0.030	.201	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.250	+/-0.010	.260	✓			
F	0.625	+/-0.030	.638	✓			
G	0.25 x 45°	+/-0.030	.251	✓			
H	0.375	+/-0.010	.385	✓			
I	19.000	+/-0.030	19.000	✓		tape	RT-10
J	0.950	+0.030/-0.010	.970	✓			
K	Ø0.260	+0.005/-0.000	.260	✓		vern	RT-4
L	Ø0.930	+/-0.030	.925	✓		vern	RT-4
M	0.30	+0.030/-0.000	.312	✓		depth gauge	RT-6
N	0.375	+/-0.030	.384	✓			
O	7.375	+/-0.030	7.375	✓		Tape	RT-10
P	4.250	+/-0.010	4.250	✓		vern	RT-4
Q	2.000	+/-0.030	1.997	✓			
R	9.000	+/-0.010	9.000	✓		Tape	RT-10
S	15.750	+/-0.030	15.750	✓		"	

Measured by: <i>RT</i>	Audited by: <i>D.A.</i>	Prototype Approval:	N/A
Date: 12-06-30	Date: 12/06/30	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>RT</i>	<i>RT</i>

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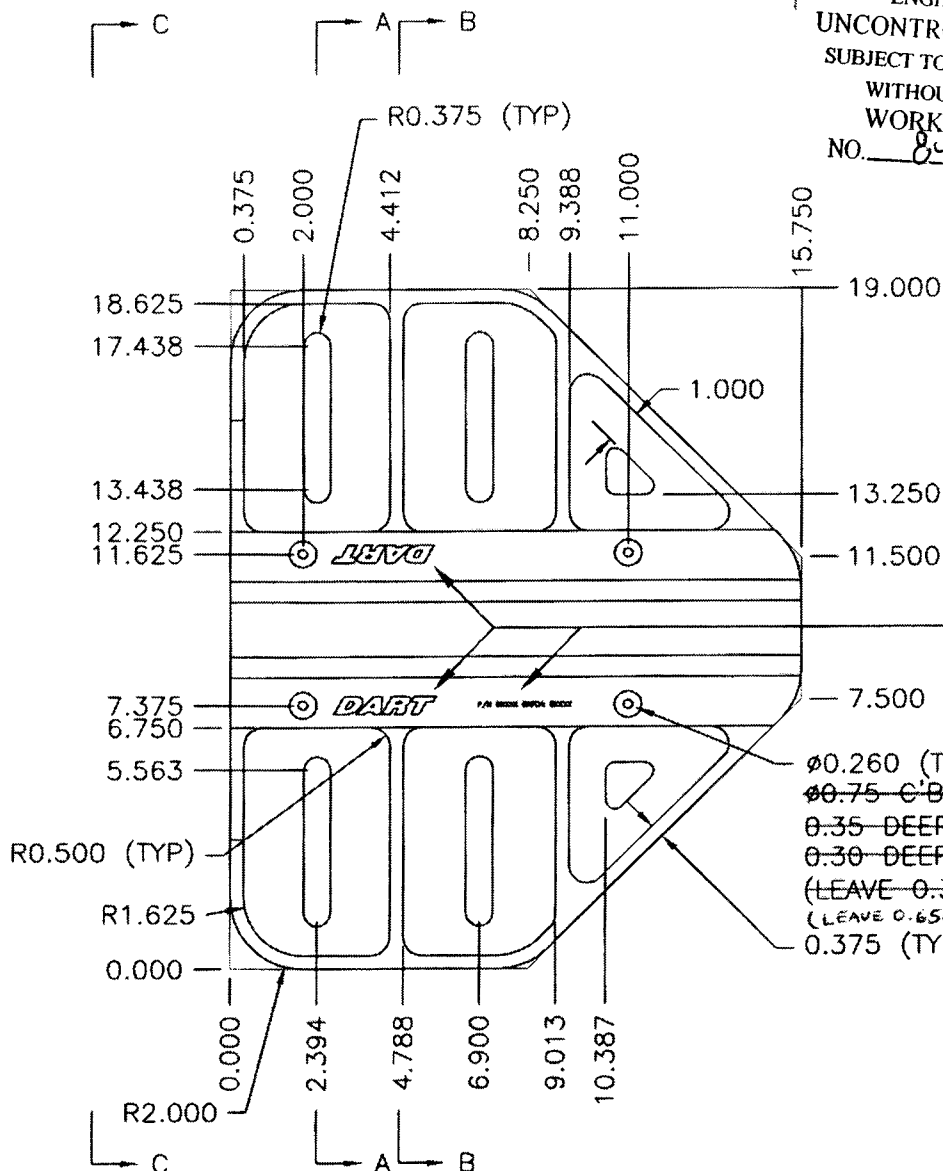
DART



RELEASED
98.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84802 MLT 12/05/23

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



0.260 (TYP) 0.93 C'BORE
0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

9143

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2435
DATE	TITLE	REV. E
98.05.19	BEARPAW	SHEET 1 OF 2
A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50
EFFECTIVE DEOS		SCALE 1:5

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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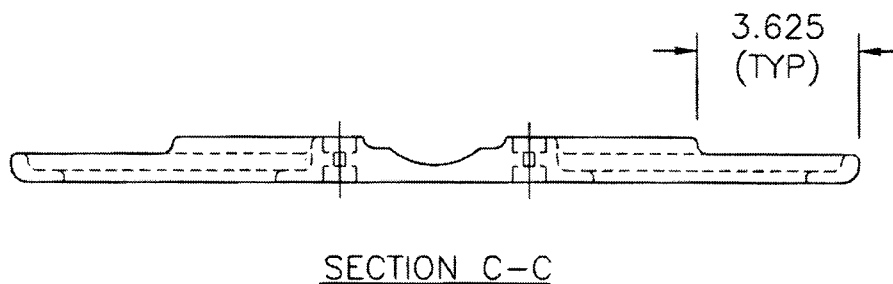
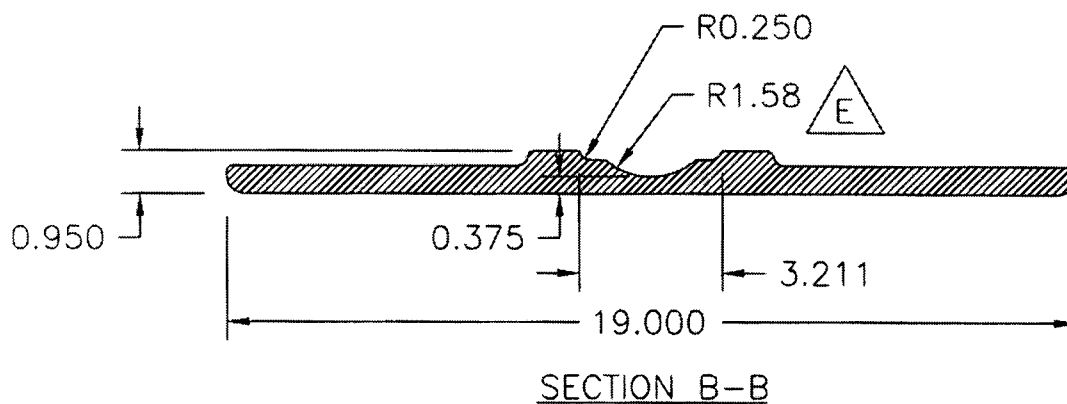
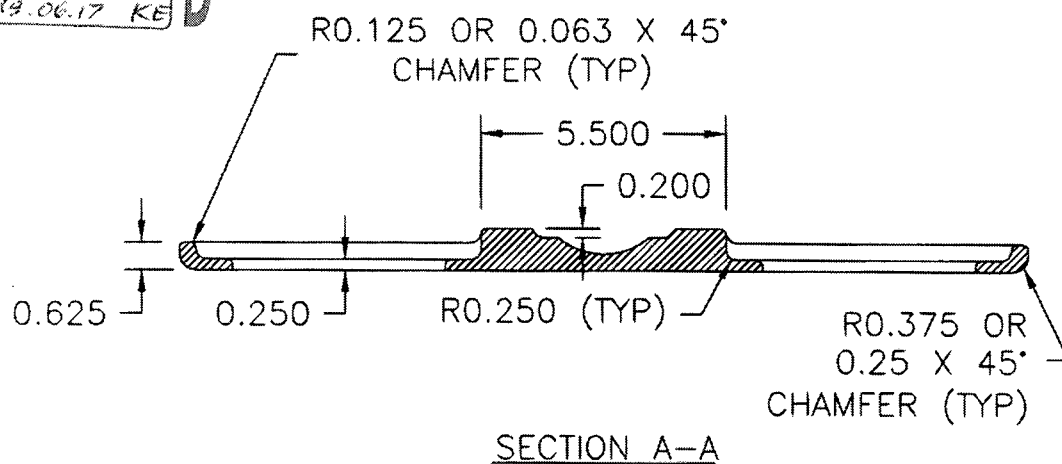
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>JS</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE



84802

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